

Work Order ID 68335

Tuesday, April 12, 2011 10:01:26 AM



Page 1

Item ID:	D3065-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	4/12/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	4/18/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-04-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3065	Rev B								

100		FLOW WATER JET	0.00						
	Waterjet	Memo	0.00						
	FLOW CNC Waterjet	1-Cut as per Dwg D3065	<input type="checkbox"/> Dwg Rev: B	<input type="checkbox"/> Prog Rev: B	<input type="checkbox"/> 2-				
		Debur if necessary							

B11-4-29

40

P/h

110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								

B11-4-29

120		QC8- Inspect parts - second check	0.00						
	QC	Memo	0.00						
	Quality Control								

8/11/04/29

196

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D8065-7 PAR #: N/A Fault Category: Small Fast Water Jet NCR: Yes No DQA: [Signature] Date: 11.05.05
Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 11/05/06

NCR: <u>B 68335</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/05/02</u>	<u>#100</u>	<u>Qty +1 Part found with a notch cutout. From water jet R.C. Part was too close to edge of mat.</u>	<u>[Signature]</u> <u>11.05.02</u>	<u>→ Scrap + Destroy Qty of no further</u>	<u>[Signature]</u> <u>11/05/02</u>	<u>[Signature]</u> <u>11/05/02</u>	<u>[Signature]</u> <u>11.05.02</u>	<u>[Signature]</u> <u>11/05/02</u>

NOTE: Date & initial all entries

Work Order ID 68335

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Item ID: D3065-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SB 1165102

Sulostoz

count
+35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 68335

Tuesday, April 12, 2011 10:01:27 AM

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Item ID: D3065-7

Accept

Revision ID:

Item Name: Step Spacer

Start Date: 4/12/2011 Start Qty: 40.00

Required Date: 4/18/2011 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

35 0 11/05/03

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

35 BR 11-5-3

180

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

11/05/04

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 68335

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Tuesday, April 12, 2011 10:01:27 AM

Item ID: D3065-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/4
35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 68335



Parent Item: D3065-7



Parent Item Name: Step Spacer

Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ C02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

97.0000

0.1574

6.627368



1811-4-29

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

97

112291

0.5

112331

32.5

113162

64

112331

40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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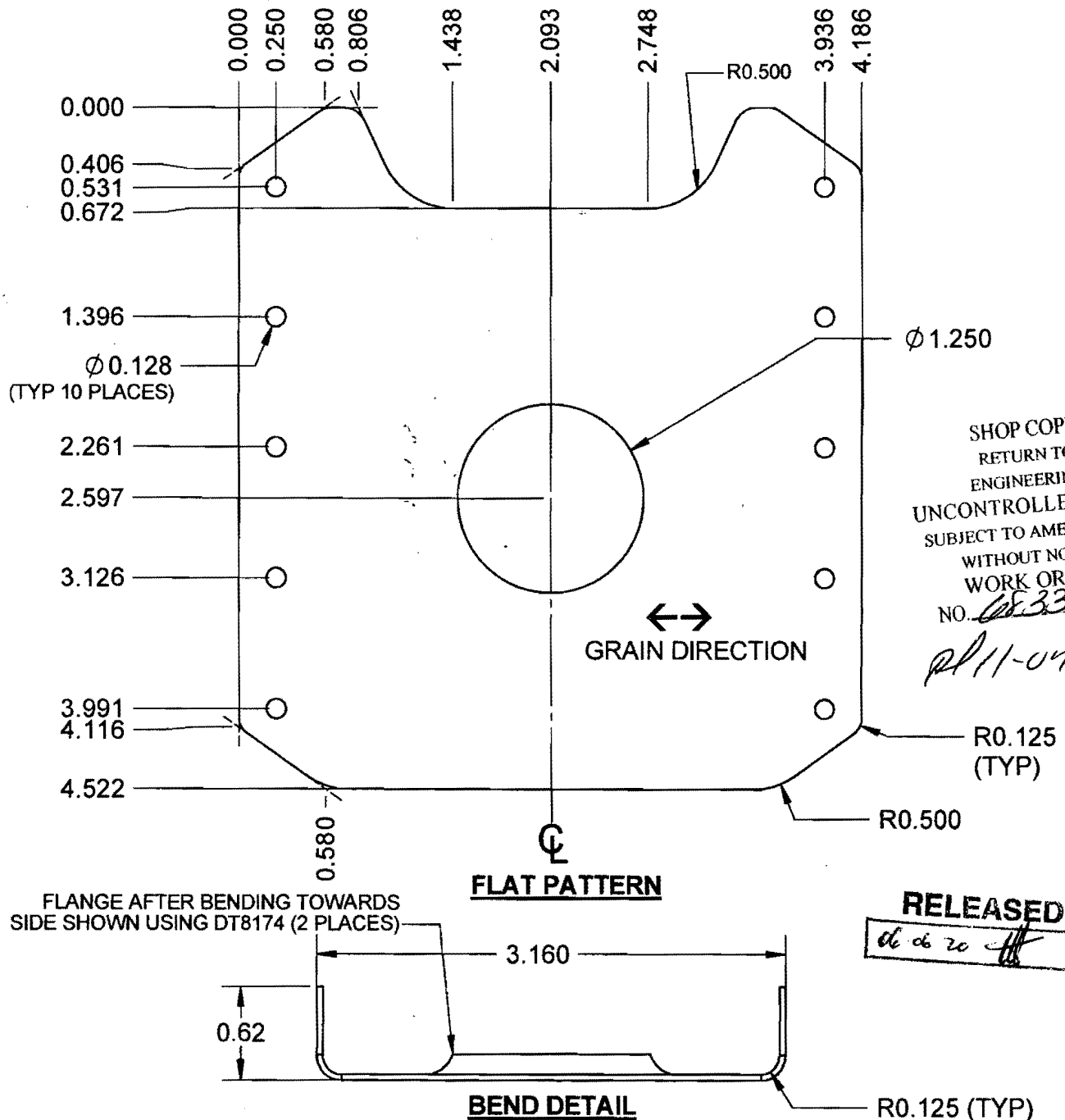
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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